

## CAN END CONVERSION SYSTEM

### Abstract of the Disclosure

[0084] A system for converting end shells into container ends complete with foil-type tabs covering pour openings formed in the shells utilizes a conveyor comprising at least one continuous belt, or a plurality of such belts operating in parallel, passing around first and second sets of drive drums. The belt(s) are driven intermittently to advance end shells in the nests first through end forming tooling and then through tab forming/attaching and reforming tools. One set, or both sets, of the drums are driven to move the belt(s) step-wise along an upper flight, such as to advance the nests in predetermined increments, and a lower return flight. The progressive end conversion tooling for shaping the shells into container ends, with formed and finished pour openings, is located in the mouth or entrance of a press, and the belt(s) passes the nests and shells therein between the upper and lower conversion tooling sets. The tab forming and application tooling is located beyond the conversion tooling but preferably within the boundaries of the mouth of the press. A supply web of foil material is fed step-wise across the conveyor(s) at the beginning of the tab forming and application station and a blanking apparatus at each of the application locations acts to create and to separate (e.g. die cut) tabs from the foil, and tack the tabs against the shells covering the pour openings. The tabs are then heat sealed over the pour opening. The areas around the pour opening=s rolled perimeters, with the foil-tabs attached, then are re-formed to provide a surface sloping slightly downward and away from the pour opening to enhance adhesion of the tabs to the shells in that region, using unique heated tooling